

# Work Order ID 86138

June-21-12 8:37:49 AM

**\*86138\***

Page 1

Item ID: D3884-2

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Saddle, Inboard RH

Stop

**\*NS2\***

Start Date: 28/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3884

B

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 86138

Double check by: RP

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

DAS  
25  
9-89

41

0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

DAS  
25  
9-89  
24 12.10.20

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, Inboard RH

Stop **\*NS2\***

Start Date: 28/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00	B.A	12/10/22		4	0		
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00				4	0	12/10/22	
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*140*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:00 OVEN TEMPERATURE: 320°F FINISH TIME: 1:30					4X	0	12/10/22	md

m122878

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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June-21-12 8:37:49 AM

**\*86138\***

Page 3

Item ID: D3884-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, Inboard RH

Stop **\*NS2\***

Start Date: 28/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:


Date:

SPC (Y/N):


Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>57431</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

H  $\phi$  12/10/22 

4 12/10/23 

12/10/24 

12-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June-21-12 8:37:53 AM

Page 1

Work Order ID: 86138

\*86138\*

Parent Item: D3884-2

\*D3884-2\*

Parent Item Name: Saddle, Inboard RH

Start Date: 28/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017		Manufactured	No				Each	4.0000		4			

\*D6101-017\*

Saddle Billet

\*\*

12-10-19

Location

Loc Qty

Loc Code

MAT047

4

74801

4

89824

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86138
<b>Description:</b> Saddle, Inboard, RH		<b>Part Number:</b>	D3884-2
<b>Inspection Dwg:</b> D3884	<b>Rev.</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.648	.648	.648	.648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.615	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.002	2.002	2.002	2.002		
J	0.140	0.175		.151	.150	.150	.150		
K	1.265	1.285		1.267	1.267	1.267	1.267		
L	0.115	0.135		.125	.125	.125	.125		
M	0.240	0.260		.251	.251	.251	.251		
N	0.110	0.140		.135	.135	.135	.135		
O	0.240	0.260		.251	.250	.250	.250		
P	2.826	2.886		2.870	2.870	2.870	2.870		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.151	.151	.151	.151		
S	0.720	0.780		.770	.770	.770	.770		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.500	.498	.500	.500		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.316	.316	.316	.316		
AA	0.760	0.765		.763	.763	.763	.763		
AB	0.215	0.220		.220	.217	.217	.217		
AC	0.316	0.321		.317	.317	.317	.317		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by:	JL / 29
Date:	12-10-19

Audited by:	BA
Date:	12/10/27

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

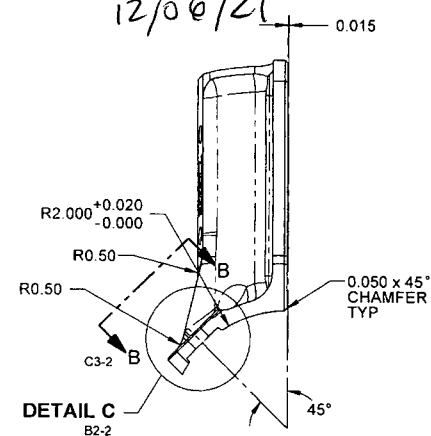
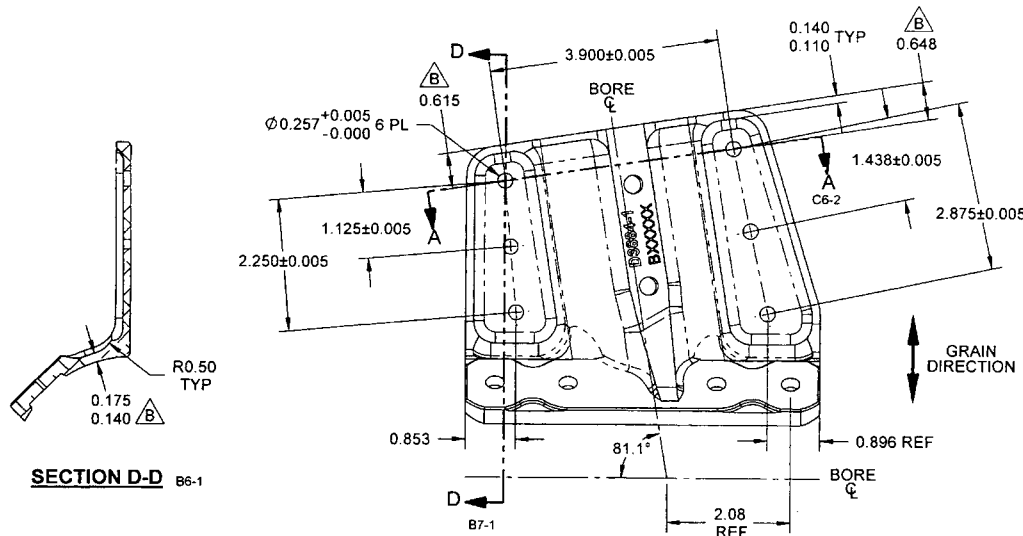
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

12/06/2



RELEASED  
09/27/15

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC 06101/017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO  
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-1; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.050. ZN C2-2; 0.75 WAS 0.65. ZN D7-2		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		
DRAWN	RF			
CHECKED	<i>RF</i>	DRAWING NO	REV. 1	
MFG. APPR.	<i>[Signature]</i>	D3884	SHEET 1 OF	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	INBOARD SADDLE	NTS	
DATE	09.06.30 COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.			

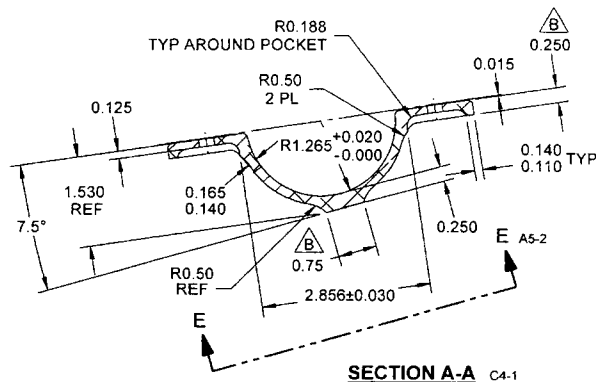
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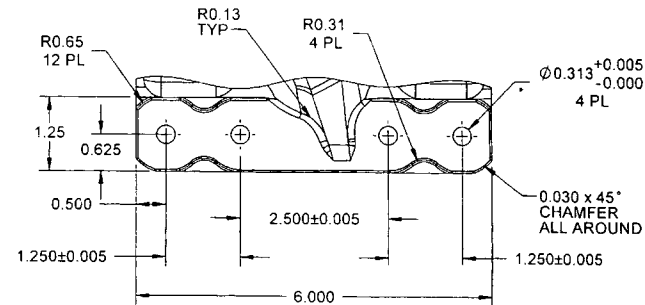
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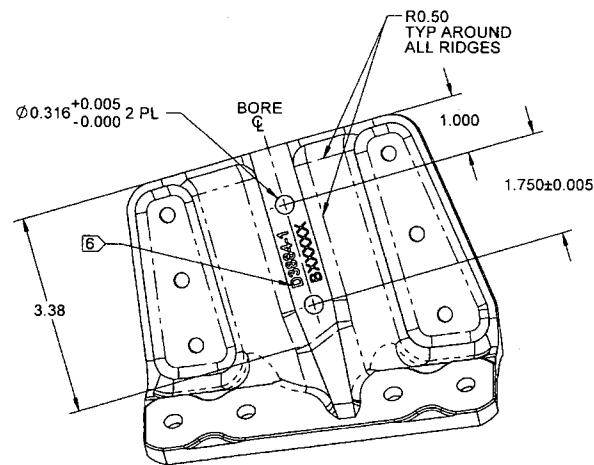
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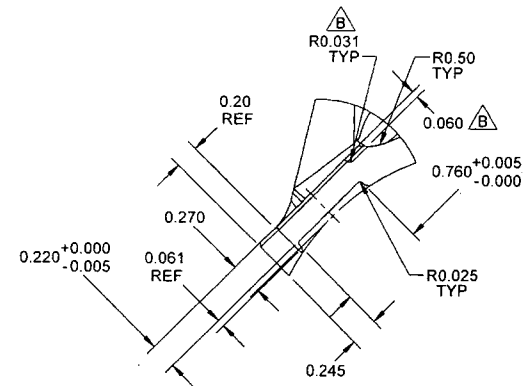
**SECTION A-A** C4-1



**VIEW B-B** B3-1  
(ROTATED FOR CLARITY)



**VIEW E-E** C6-2



**DETAIL C** B3-1  
SCALE 2X

**RELEASED**  
09/07/15/10

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3884</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>INBOARD SADDLE</b>	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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